Work Order ID 111222

January-09-14 12:49:35 PM Rev E 1/01/14 *111222*

PRELIMINARY ISSUE

Item ID: D4635-2 Accept *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd Ceiling Panel, RH

Start Date: 09/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MP **Date:** 14-01-09 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4635	Revision Nbr: ~~RD2 REV~~ Rev E	DAS 27 9-89 per ECN14509							
100	HAND FINISHING THERMOFORMING	0.00							
100						x1			14/01/14
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							
105						x1			14/01/14
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

Temp: 245° F

Time IN: 5:00 pm 14/01/13

Time OUT: 6:00 am 14/01/14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Item ID: D4635-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, RH
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x1			14/01/14
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-2 and Folio FTA148								
	Dwg. Rev. PE1								
	Folio Rev. C								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					x1			14/01/18
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						x1			14/01/18
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4635-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, RH
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89				1			
150 QC Quality Control	**Memo**	0.00 14/1/23				Inspect as per Rev pb2			
160	Packaging	0.00							
160 Packaging Packaging	**Memo**	0.00				thermoforming MCJ			
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00				MCJ 14-1-23			

POSITIVE RECALL
EFFECTIVE 4/11/22 AUTH _____
RELEASED _____ DATE 14/01/24

MF 14-1-21

Release Rev E DAS 27 9-89 14/1/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
Suspected Unapproved ☐

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

January-09-14 12:49:42 PM

Work Order ID: 111222 *111222*

Parent Item: D4635-2 *D4635-2*

Parent Item Name: Fwd Ceiling Panel, RH

Start Date: 09/01/2014 **Required Date:** 24/01/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev D Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	14.9	15			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

15 sq ft.

14/01/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Temperature/Cure
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☐ Wrong Stock Pulled
☐ Other _____

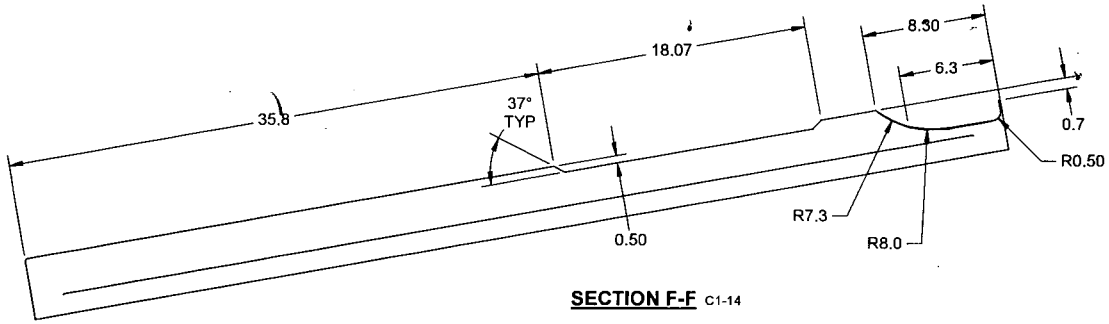
DART AEROSPACE LTD

Description:	PANEL.			**Work Order:**	111722
Inspection Drawing:	D4635	Rev:	PE1	Part Number:	D4635-2

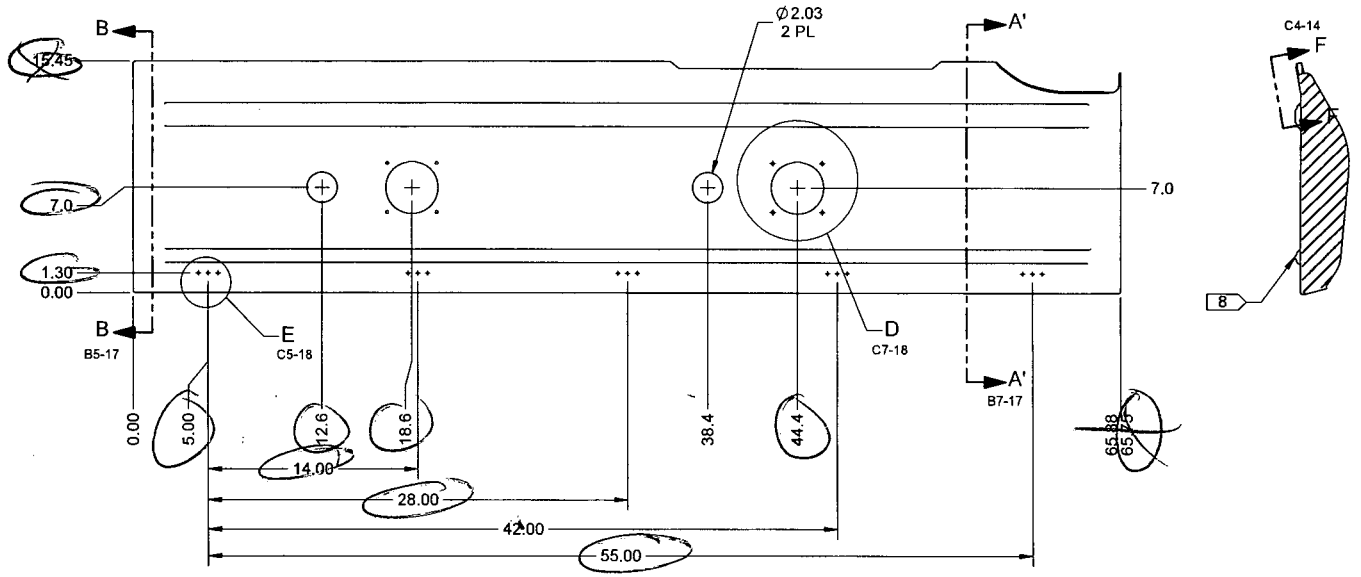
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.30"	+/- .030	.31"	✓		Vern DL-02	
.35"	.35-.40	.398"	✓		"	
.150"	+/- .030	.154"	✓		"	
Ø 3.50"		3.53"	✓		"	
Ø 2.03"		2.00"	✓		"	
Ø 0.191"	+.005-.001	0.191"	✓		"	
Ø 0.129"	+.005-.001	0.129"	✓		"	
65.75	+/-0.030	65.72	✓		tape	SFAB-21
5.00	+/-0.030	5.00	✓		"	"
12.6	+/-0.100	12.6	✓		"	"
18.6	+/-0.100	18.6	✓		"	"
28.60	+/-0.030	28.00	✓		"	"
38.4	+/-0.100	38.4	✓		"	"
44.4	+/-0.100	44.4	✓		"	"
55.00	+/-0.030	55.00	✓		"	"
15.45	+/-0.030	15.45	✓		"	"
7.00	+/- 0.100	7.0	✓		"	"
1.30	+/-0.030	1.30	✓		"	"
42.00	+/-0.030	42.00	✓		"	"
38.4	+/-0.030	38.4	✓		"	"
3.4	+/-0.100	3.300	✓		Vern	SFAB-08
0.350	+/-0.030	0.34	✓		Vern	SFAB-08

Measured by: DL	**Checked By:** DA 2 9-6	**QC inspector:**	**Engineering Approval** (*if necessary*)**:**
Date 14/01/18	**Date** 14/1/20	**Date**	**Date**



SECTION F-F C1-14

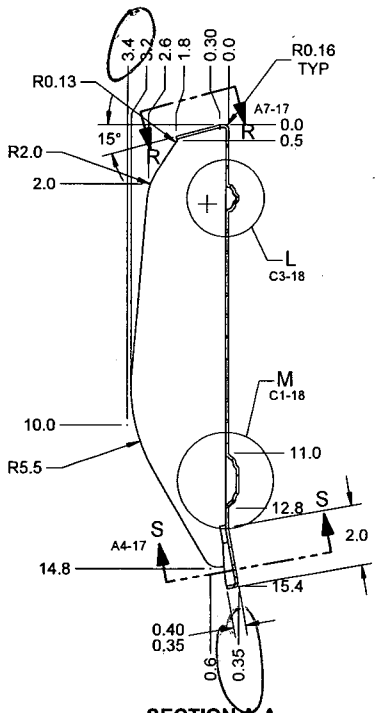


NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.37 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-2 PER TOOL DT9840
10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

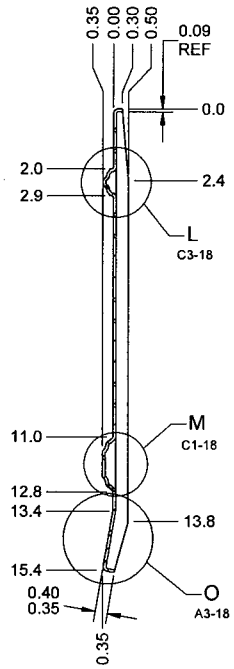
D4635-2 RH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 14 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

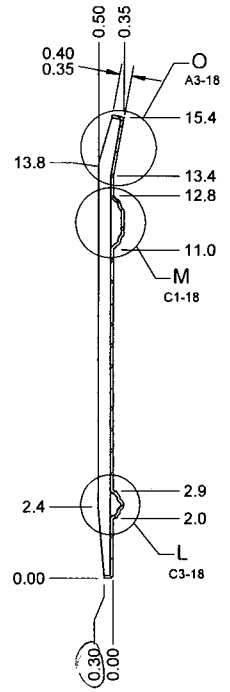
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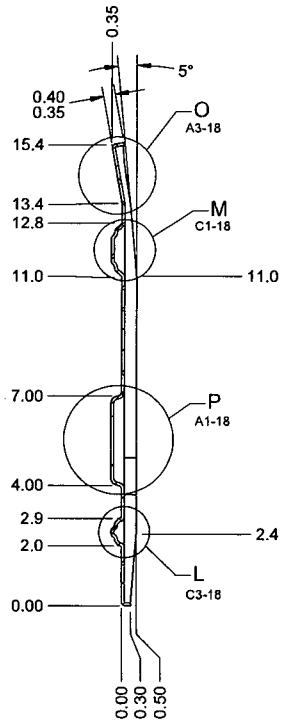
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



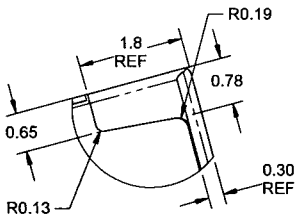
SECTION B-B B7-13 B7-14
SCALE 2X



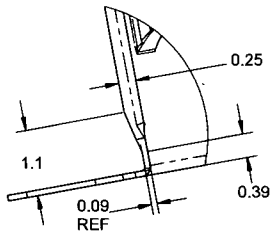
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X

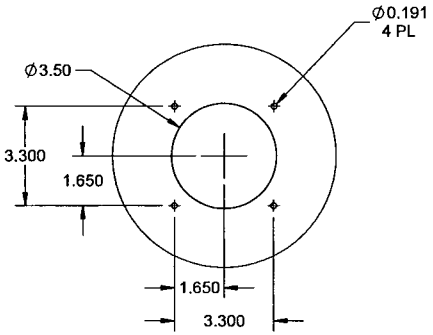


AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X

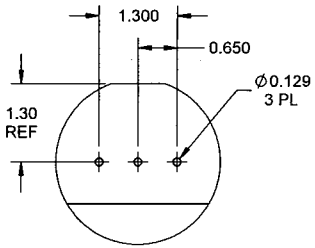


AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

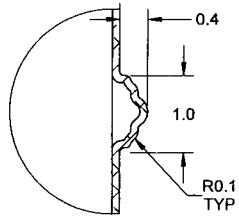
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. PE1
MFG. APPR.		D4635	SHEET 17 OF 18
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



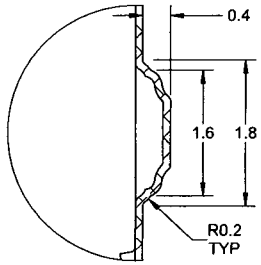
DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



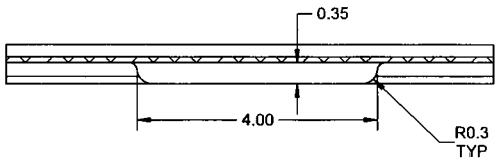
DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



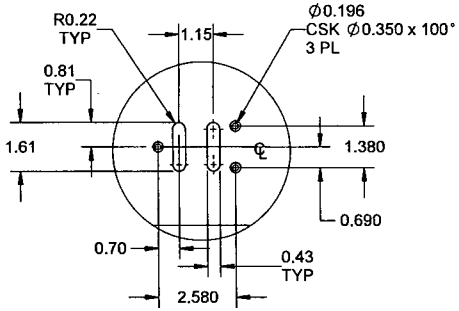
DETAIL L B2-17 B4-17 C5-17 C7-17
SCALE 1.5X



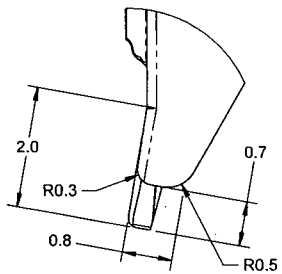
DETAIL M C2-17 C3-17 C5-17 C7-17
SCALE 1.5X



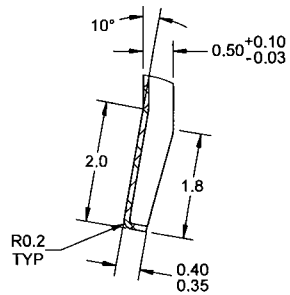
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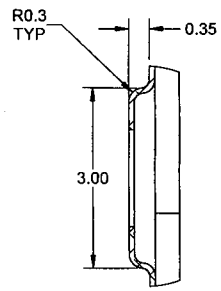
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DETAIL N B2-13
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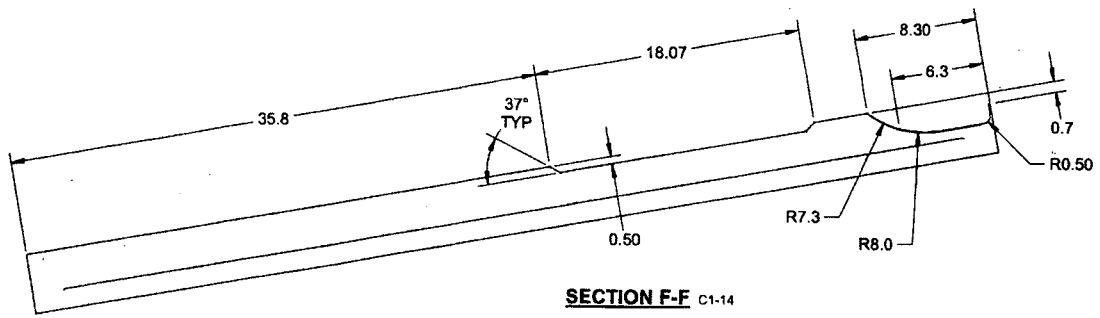
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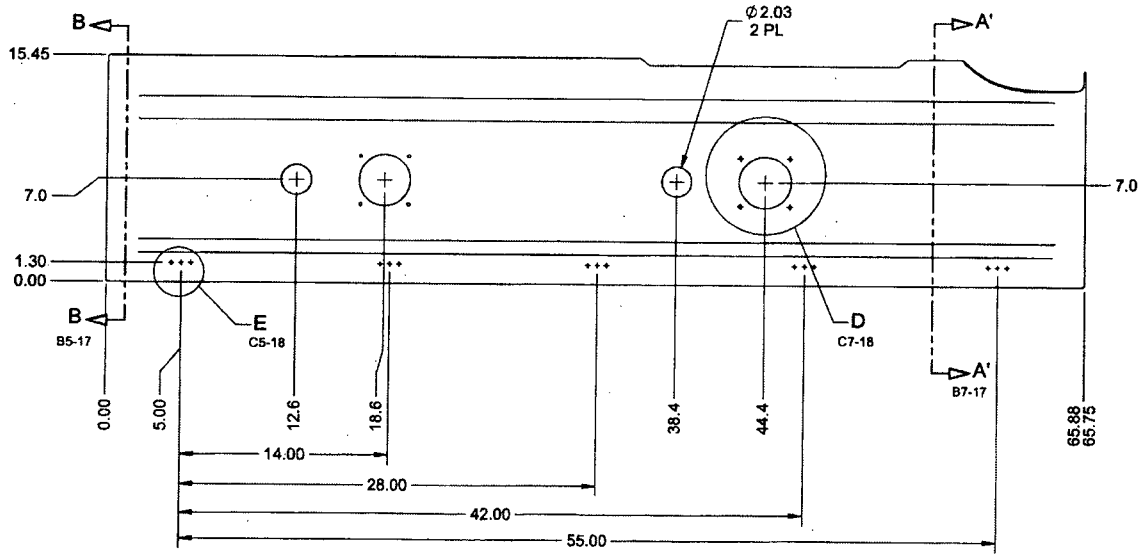
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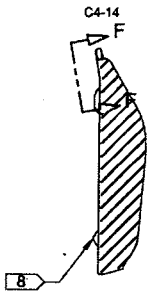
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DRAWN	RF	
CHECKED	JC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 18 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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SECTION F-F C1-14



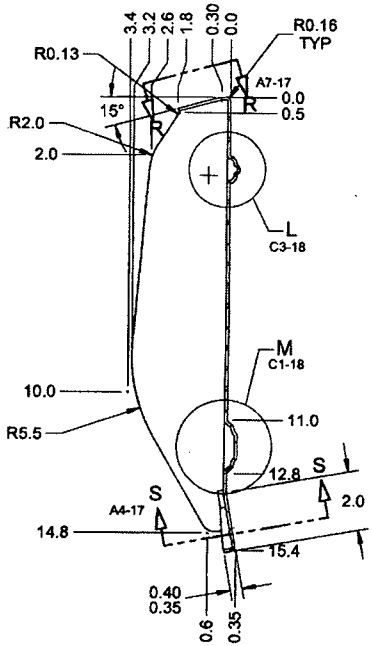


NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.37 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-2 PER TOOL DT9840
10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

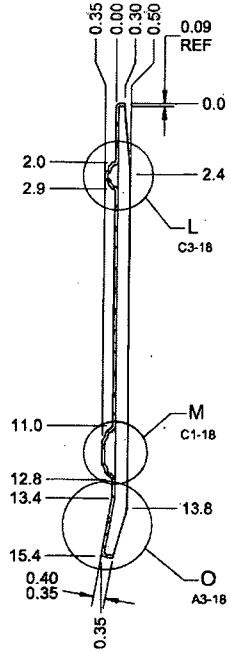
D4635-2 RH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 14 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

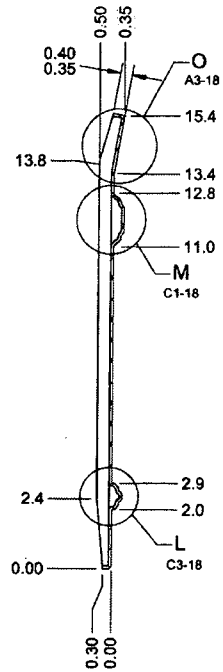
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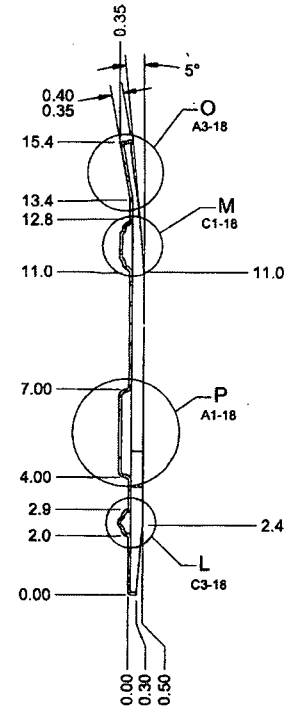
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



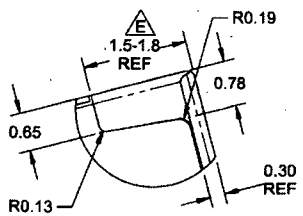
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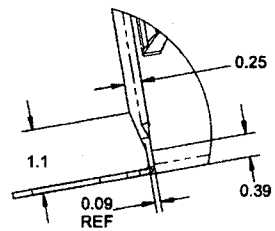
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X

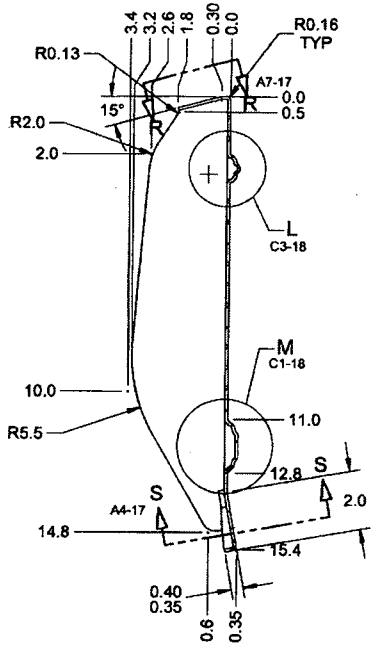


AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

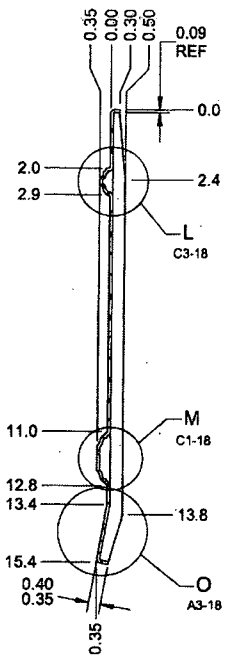
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DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED	DC	SHEET 17 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

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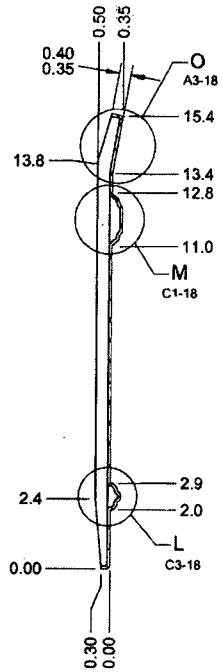




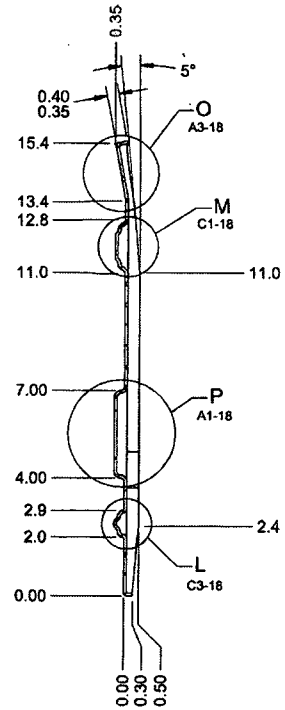
SECTION A-A B3-13
SECTION A'-A' OPPOSITE B3-14
SCALE 2X



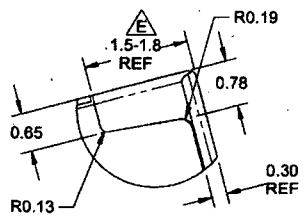
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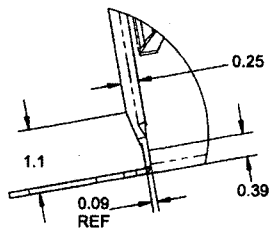
SECTION G-G B4-15
B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

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DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. E
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